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D3914-041
Job Sheet 184062



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Large Fab-5		C 10/16/18
100	Large Fab	1 pcs	11/9/18	11/9/18	0.00	6.67	Large Fab 1		C 10/16/18
110	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC9		C 10/16/18
120	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC5		C 10/16/18
130	Powdercoat	1 pcs	11/9/18	11/9/18	0.00	0.40	Powdercoat4		BL 10-10-28
135	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC3		ML 10-10-28
140	HandFinish	1 pcs	11/9/18	11/9/18	0.00	0.80	HandFinish3		ML 10-11-26
150	QC	1 pcs	11/9/18	11/9/18	0.00	0.00	QC3		ML 10-11-25
160	Packaging	1 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-2		DAS 10-11-25
170	QC21-SA	1 Ea	11/9/18	11/9/18	0.00	0.00	QC21		OCT 25 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***

M 138839 START: 10:20 OUT: 3:00 FINISH: 10:40

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5097502
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	5112316
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	5113730
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5110937
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	5110523
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	5113739
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	5114284
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	5111126

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

90-Start up Operation

D2581	2	76	0
D3914-1	2	5	0
D3914-7	2	10	0
D4016-3	3	195	0
D4018-5	9	42	0
D4020-5	1	10	0
D4021-3	1	33	0
D4035-043	2	16	0

Part Specifications

Specifications could not be found.

Plex 10/2/18 11:02 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____

Part No. _____

NCR No. _____

Date : _____

Description \

Job No 184062



Master Unit 005837

Part: D3914-041
Job No: 184062
Serial No/Batch: S118622
Revision: A/D
Inspector:
Exp Date:
Instructions: Various STC's

Date: 10/16/18

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QC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

☐ Pressure/Forced
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Wave/Twist in Tube
☐ Marks/Chatter

OTHER :

FAULT CATEGORY

☐ Temperature/Cure
☐ Set-up
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Inspection Incomplete/Unqualified
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Instructions Incomplete/Unclear
☐ Drill Holes

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set
☐ Mislabeled
☐ Fit/Function
☐ Misaligned/off center

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence